

Date: Wednesday, 8/15/2007 7:57:12 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR PROTECTOR AFT RH
Job Number	: 33900	Part Number	: D32814
Estimate Number	: 11235	Drawing Number	: D3281 REV <i>BC</i>
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 8/15/2007 S.O. No. : <i>N/A</i>	Drawing Revision	: <i>8</i>
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : THERMOFORMING	Due Date	: 8/22/2007
Previous Run	: 30661	Qty:	10 Um: Each
Written By	: <i>JL 07-08-15</i>		
Checked & Approved By	:		
Comment	: Est Rev A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL		

**ENGINEERING
APPROVAL**

PRELIMINARY
LE 07.10.16

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 F6002 701 lexan black



Comment: Qty.: 4.3600 sf(s)/Unit Total : 43.6000 sf(s)
 lexan black .125"

Material Batch # *M 103735* (x8) *34.86*

M 105952 (x16)

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



xs

Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

DL 07/08/21 (x8) *DL 07/10/30* (x10) *P10*

3.0 THERMOFORMING THERMOFORMING MACHINE



xs

Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 010

Dwg. Rev. *B*Folio Rev. *B*

DL 07/08/21 (x8) *DL 07/10/30*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DL 07/08/21 (x8) *DL 07/10/30* (x10)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR AFT RH

Job Number: 33900

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

LL 07/10/30 (x10)
BB 07-10-05

(x8) (PTO)

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

LL 07.10.05
LL 07.10.30 06

7.0

QC5

INSPECT WORK TO CURRENT STEP



POSITIVE
RECALL

Comment: INSPECT WORK TO CURRENT STEP

LL 07/11/09

8.0

PACKAGING 1

PACKAGING RESOURCE #1



ENGINEERING
APPROVAL

LL 07.11.06



Comment: PACKAGING RESOURCE #1

LL 07/11/09 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

LL 07.11.06

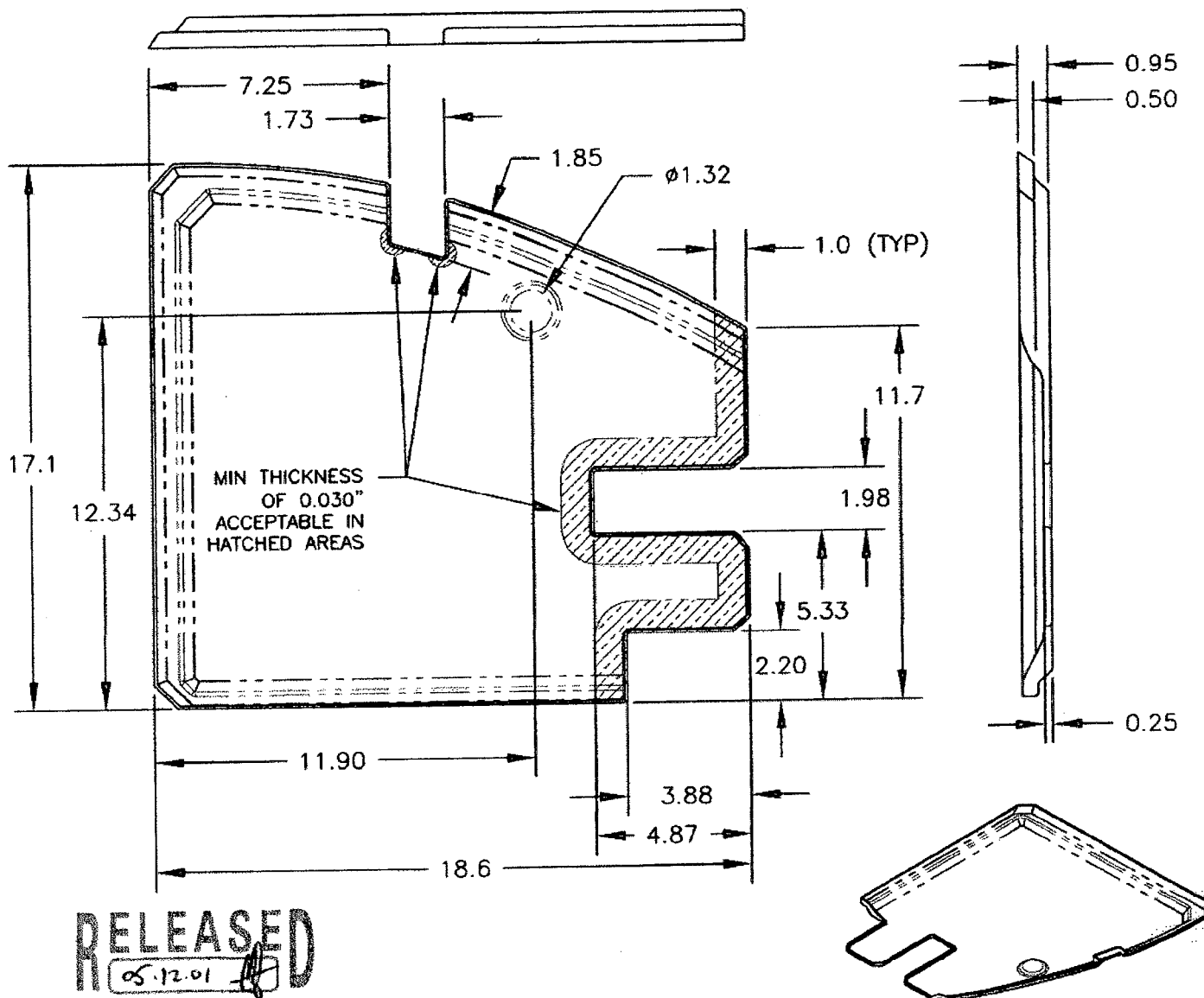
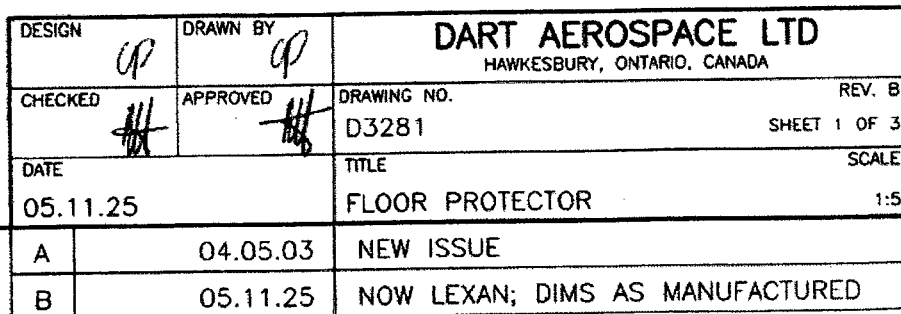
Job Completion



POSITIVE RECALL

EFFECTIVE 07-08-05 AUTH LL

RELEASED LL DATE 07.11.06

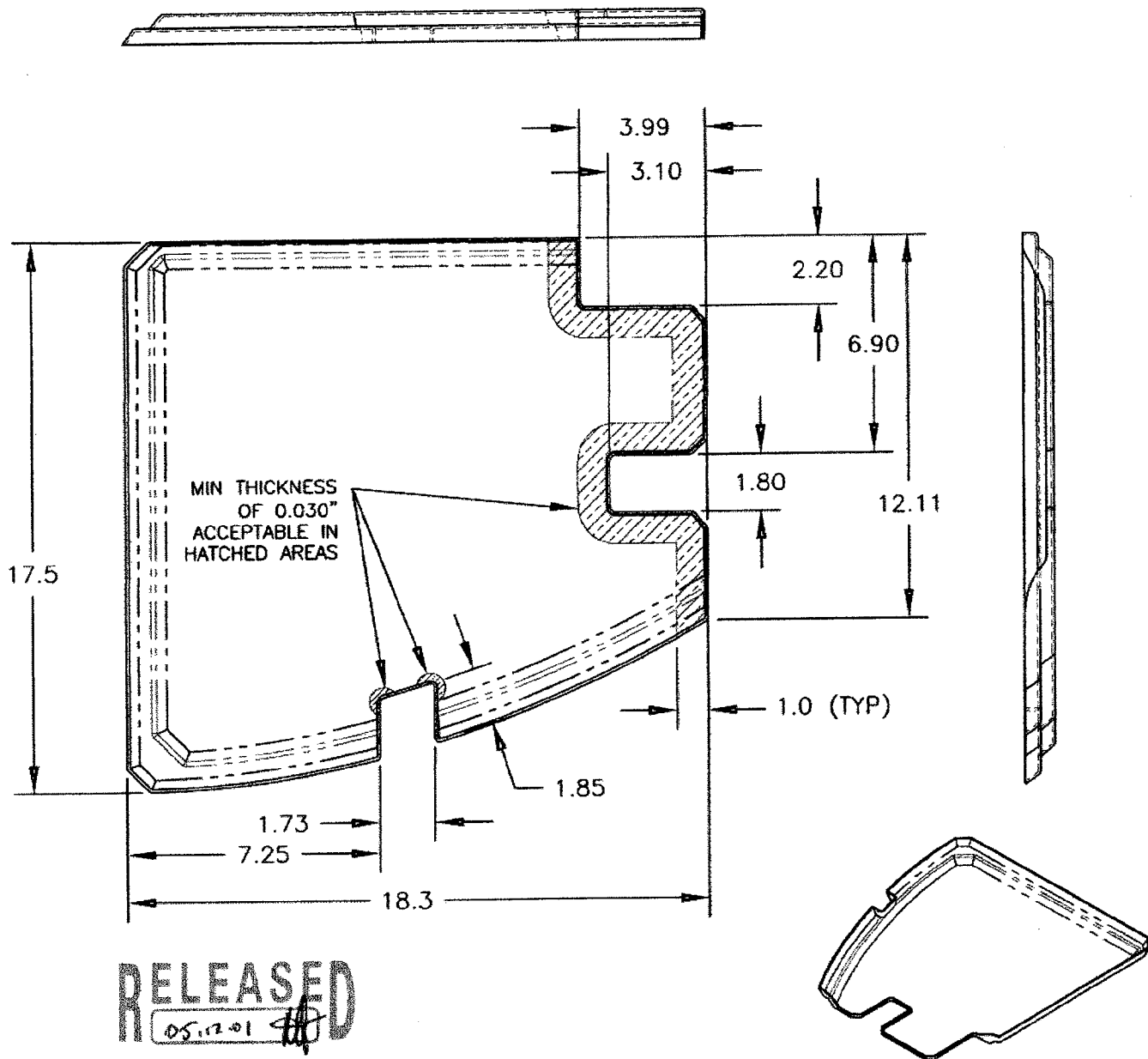


1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



D3281-2 FLOOR PROTECTOR, FWD RH

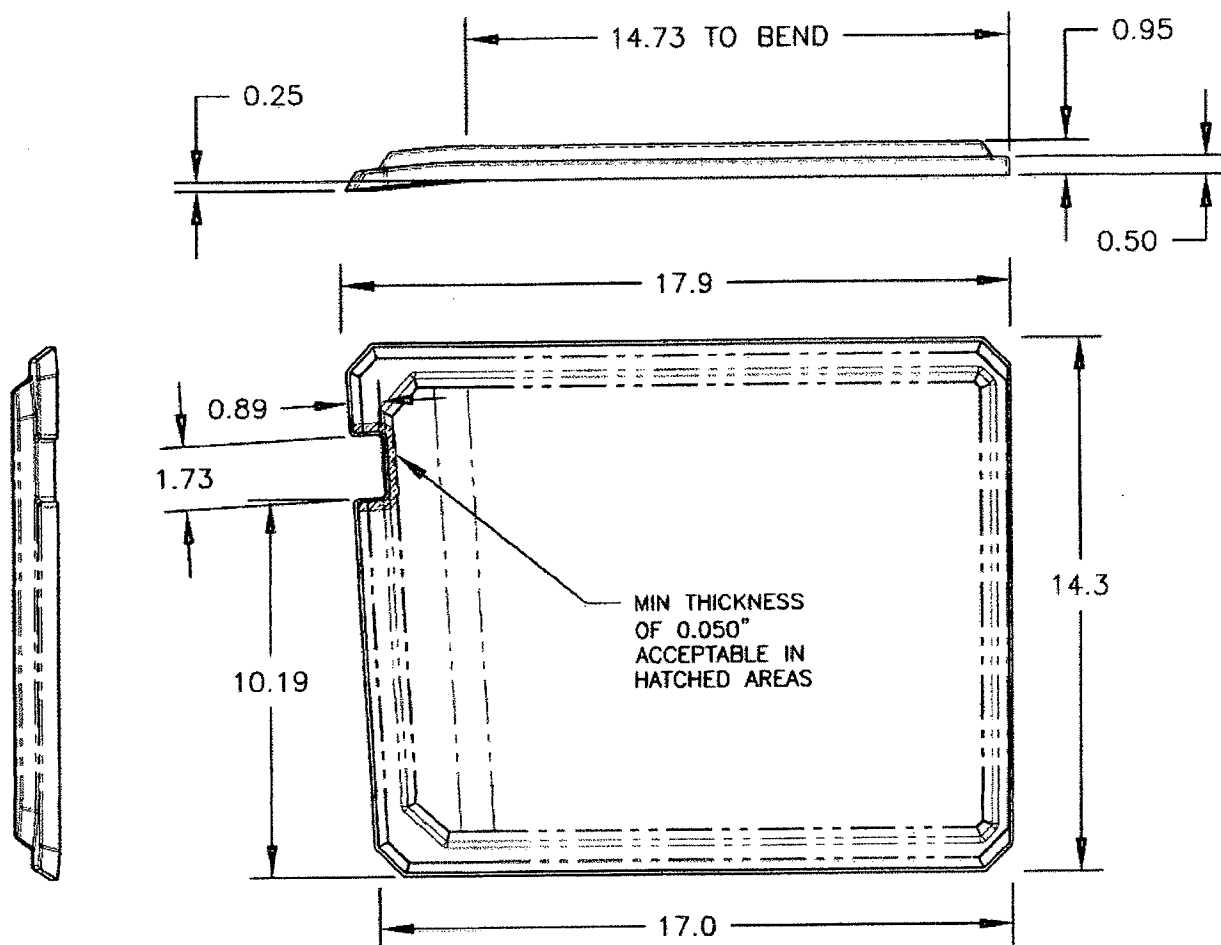
- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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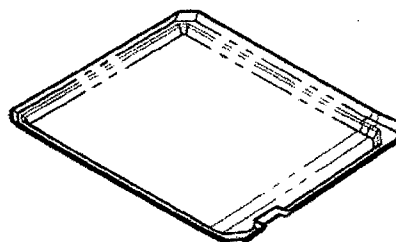
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CHECKED	APPROVED	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5



RELEASED
05.12.01.

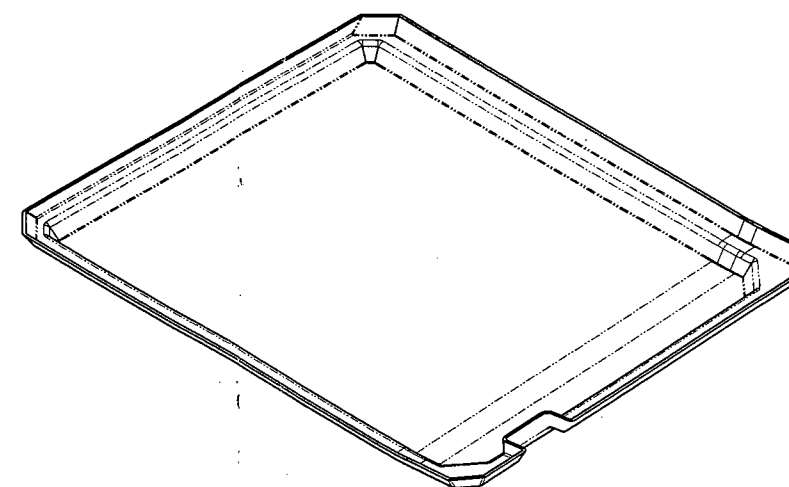
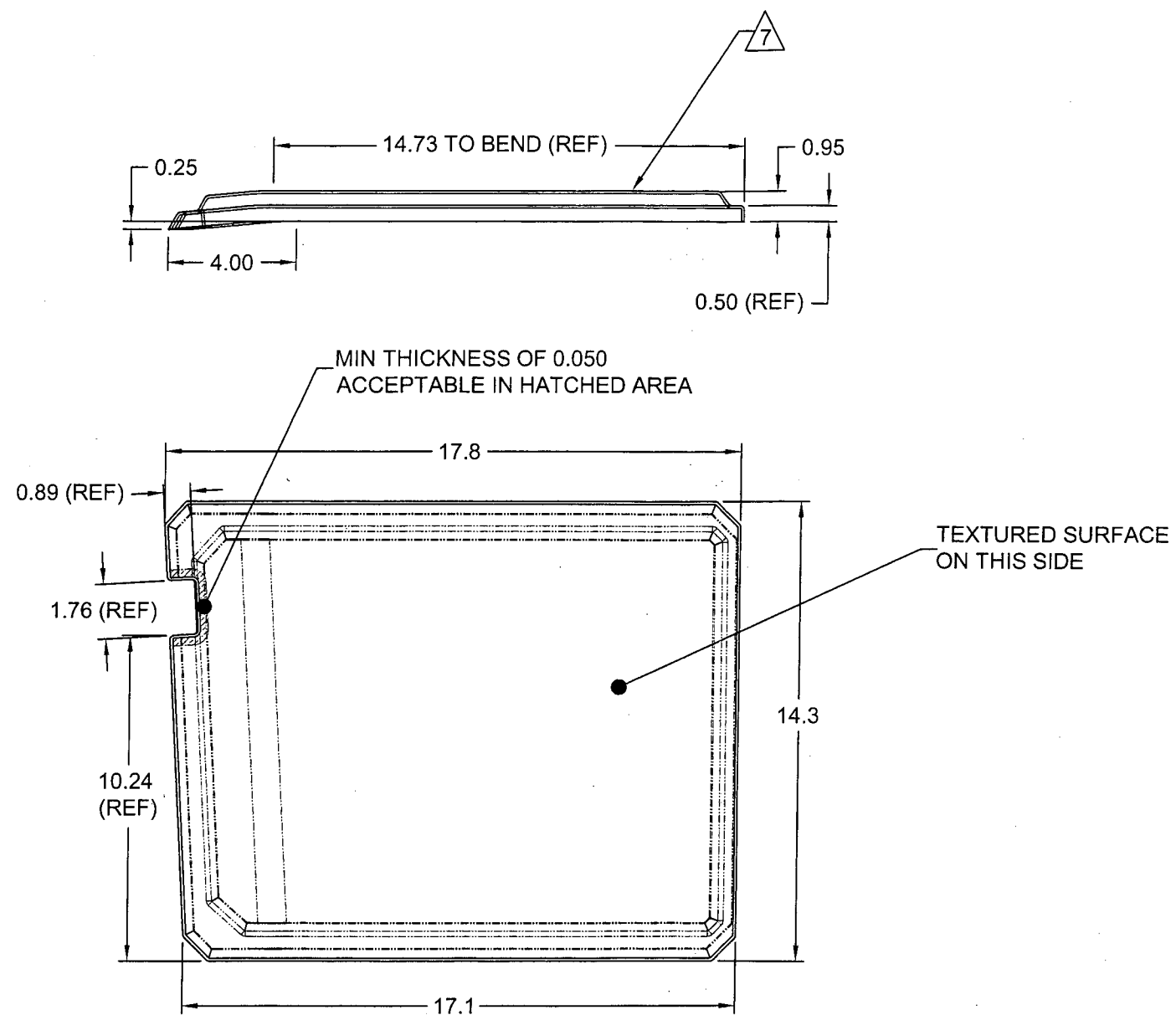


D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33900

PRELIMINARY ISSUE

LE 07.10.16

D3281-3 FLOOR PROTECTOR
(D3281-4 OPPOSITE)

D3281-3/-4 NOTES:




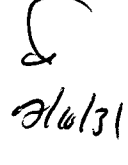
- 1) THERMOFORM WITH MOLD D3281-3T1 FOR D3281-3 AND D3281-4T1 FOR D3281-4 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3/-4" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	et	DRAWING NO.	REV. C
MFG. APPR.	46	D3281	SHEET 3 OF 3
APPROVED	AM	TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	07.10.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.25	6	8 parts not formed. material Batch A103735	 07/11/05	Scrap & Replace.	02/10/25 W.L.	 07/10/31	 07/11/05	 07/10/31

NOTE: Date & initial all entries

DART AEROSPACE LTD		WORK ORDER: 33900
Description: R44 Floor Protector Rear RH		Part Number: D3281-4
Inspection Dwg: D3281	Rev: B	Page 1 of 1

< Preliminary.

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Inside Radii less than 3/16" go/no go	lt
Acceptable shape definition	lt
Acceptable texture retention	lt
Free of visual flaws (bumps, cracks, voids, etc.)	lt

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3281 Rev. ~~B~~ and record below

< preliminary.

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.8	.1	17.75	✓		TAPE	
12.1	.1	12.065	✓		TAPE	
14.3	.1	14.25	✓		TAPE	
10.24	.030	10.25	✓		TAPE	
.95	.030	.958			CAL.	Acceptable
4.0	.030 .125	1.25		✓	CAL.	Bad MEAS con Draw.

Measured by: <i>lt.</i>
Date: 07.10.31

Audited by: <i>[Signature]</i>
Date: 07/10/31

Prototype Approval: <i>lt</i>
Date: 07.11.01

Rev	Date	Change	Revised by	Approved
		New Issue		